Work Order I Tuesday, October 04										•	Page
Revision ID: Item Name: Lug		art Qty: 12.00 eq'd Qty: 12.00		Accept	Cust Item Customer:				Setup Star Stop		
;	ocess Plan: _	4 L. J	Date: 11 10			oate:		1	Run Star Stop		
Sequence ID/ Work Center ID		eration scription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr			•						PIN SUBSTITUTE A STATE OF THE S
D3405	Rev B		-	<u> </u>							
1 00 1 1 2 3 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	ri ć	OW WATER JET		0.00							
Waterjet	ric			0.00				B11	-10-05		• • • • • • • • • • • • • • • • • • • •
FLOW CNC Waterjet		Memo 1-Cut as per I Dwg Rev: Prog Rev: 2-Deburr if no	<u> </u>	86-0		·				(14))
110	QC2	2- Inspect parts off ma	chine FAI/FAIB	0.00							
			·	0.00				Bl	6-01-	<u>ځ</u>	
QC Quality Control	:	Memo		0.00							
	e.										
20 	QC8	3- Inspect parts - secon Memo	d check	0.00	10/26		-	44)		

Dan Ae	rospace	ELIO							
W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	\ :	Date:	
	R	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector

Page 2

Tuesday, October 04, 2011 9:57:53 AM

Item ID:

D3405-043

Accept



Setup Start



Stop

Revision ID:

Item Name:

Lug Assembly

Start Date: Required Date: 10/14/2011

9/30/2011

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: ___

Tooling:

Date:

Tool ID

Date:

Tool #

Plan

Code

Accept

Qty

Run Start

Reject

Qty

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ Work Center ID



1 Brake NC

Brake NC

Operation Description Set Up/ Run Hours

SPC (Y/N):

0.00

0.00

NC BRAKE

Memo

1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming

SB 11/11/03

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 117657 0.00 Large Fab

Memo

0.00

Weld as per Dwg D3405 use DT8484

Identify as D3405-043

EZ 11-11-14

W/O:		WORK ORDER CHANGES					÷
DATE	STEP	PROCEDURE CHANGE	By Date		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				:			
						,	
	1						

Part No:	PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:	
Resolution:		Disposition:	QA: N/C Close	1 :	Date:	

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B	Verification	Annroval	Approva			
STEP	Section A	Initial [*] Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto		
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	,								
	STEP	Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Section B Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Corrective Action Section B Verification Approval Chief Eng		

Required Date: 10/14/2011



Page 3

Tuesday, October 04, 2011 9:57:53 AM

Item ID:

D3405-043

Lug Assembly

Accept



Setup Start



Stop

Item Name: **Start Date:**

Revision ID:

9/30/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

160

QC

Quality Control

Operation Description

OC9- Inspect visual per QSI004- Fusion Welds

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept **Oty**

Reject Otv

Reject Number

Insp. Stamp

Memo

0.00

0.00

170

Ouality Control

QC5- Inspect part completeness to step on W/O

180

Powdercoat

W 118439

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

FINISH TIME:

Memo

START TIME: OVEN TEMPERATURE:

14XDm/11/11

W/O:				WORK ORDE	R CHANGES					
DATE	STEP		PROC	EDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		<u></u>								
Part No	:		_PAR #:	Fault Category:	NCF	R: Yes	No DQ	A:	_ Date: _	· · · · · · · · · · · · · · · · · · ·
	R	Resolution:		Disposition:	QA:	N/C C	losed:		Date:	

WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B		Varification	Approval	Approval		
STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspecto		
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	STEP	STED Description of NC	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Corrective Action Section B Verification Section C Section A Chief Eng Ch	STEP Description of NC Section A Initial Chief Eng Chief Eng Sign & Date Chief Eng Chi		

Page 4

Tuesday, October 04, 2011 9:57:53 AM

Item ID:

D3405-043

Accept



Setup Start



Stop



Revision ID: Item Name:

Lug Assembly

Start Date:

Required Date: 10/14/2011

9/30/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Stop

Date:

SPC (Y/N):

Set Up/

Date:

Insp.

Sequence ID/ Work Center ID

190



QC

Memo

OC3- Inspect Part Finish

Operation

Description

Run Hours

0.00

Tool # Plan Code

Accept Qty

Reject Otv

Reject Number

Stamp

Quality Control

0.00

200



Packaging

Identify as per dwg & Stock Location: 4 45

0.00

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

Quality Control

0.00

ME 11-16

W/O:		WORK ORDER CHANGES					•
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·							
			• >/			5-4	

Part No:	PAR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NÇR:	CR: WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
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					!					

Picklist Print

Tuesday, October 04, 2011 9:57:58 AM

Work Order ID: 74550

Parent Item:

D3405-043

Parent Item Name: Lug Assembly



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Page 1

Comments:

IPP $A \square 05.09.01 \square New issue \square KJ/JLM \square$

IPP B 09.01.28 Rev b dwg EC verified by: DD

	07.01.20	110.045											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	20.0000	1	12 A	11-11-14	4	
				Location	Į.	Loc	<u>Qty</u>	Loc Code					
7	4551 x	6		WA	70664		7 7			· · · · · · · · · · · · · · · · · · ·	-		
		. *		WA030	72326		13 13	e wy		8	·	_	
		Purchased	No			150	sf	143.9000	0.154	1.945263	BII-10-		·
304/316 0.125 Sheet				Location		Loc	Qty	Loc Code		(6,	
				MAT020			143.9		_		,	(学	
					117494		15.9				-	4)
					119006		64		.		-		
					119048		64		Ĺ	19049			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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····	1						

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
Resol	lution:	Disposition:	QA: N/C Closed		Date:

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
	T	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
·-···							1	
					ļ			
							·	
					:			2

DART AEROSPACE LTD	Work Order:	74550
Description: GHW Bracket	Part Number:	D3405-3
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	,439	3		V RSZ	
1.50	+/-0.030	1.501	7		V	
1.750	+/-0.010	1.749	7		V	
R0.63	+/-0.030	,63	2 2		RiG	
3.00	+/-0.030	2.997	7		V	
8.00	+/-0.030	7,998	0		V	
6.751	+/-0.005	6.753	>>		V	

Measured by: 🦹	Audited by:	Prototype Approval:	N/A
Date: 1 (0 - 35	Date: 11/0/25	Date:	N/A

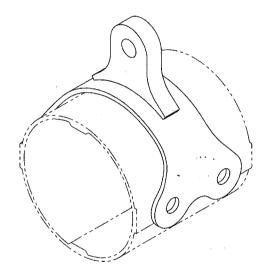
Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue P/O D3405-043	KJ/JLM	111
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	
	<u> </u>		1	- June

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			i				

Part No:	_ PAR #:	Fault Category:	NCR: Yes No DC	QA:	Date:
Resolution:		Disposition:	QA: N/C Closed: _		Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Verification	Approval	Approval			
DATE	DATE STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
out of the second											
		:									

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	1/1
1	х		D3405-041	LUG ASSEMBLY	7
2		х	D3405-043	LUG ASSEMBLY	
11	1	1	D3404-1	GHW LUG	
12	1		D3405-1	GHW BRACKET	
13		1	D3405-3	GHW BRACKET	



D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 7450 4.C. J

D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



В	DRAWIN STANDA FLAT PA PREVE ZONE A	ARDS A	AJS	08.09.19				
A	NEW IS	SUE			PH	05.03.08		
REV.			DESCRIPTION	BY	DATE			
DESIG	١	P	γH	DART AEROSPACE LTD				
DRAW	1	Α	s	HAWKESBURY, ONTARK				
CHECK	ED			DRAWING NO.		REV. B		
MFG. A	PPR.	M	$\overline{\Omega}$	D3405		SHEET 1 OF 4		
APPRO	VED	lim	P	TITLE		SCALE		
DE APPR. GHW LUG ASSEMBL				Y	NTS			
DATE 08.09.19				COPYRIGHT © 2005 BY DART AI THIS DOCUMENT IS PRIVATE AND COMPRIBITION, AND IS SUPPLIED NOT TO BE USED FOR ANY PLRIPOSE OR COMPLIANCE. WHETTEN REPORTSION FROM DURL ARE	ON THE EXPRE TED TO ANY OT	SS CONDITION THAT IT IS		

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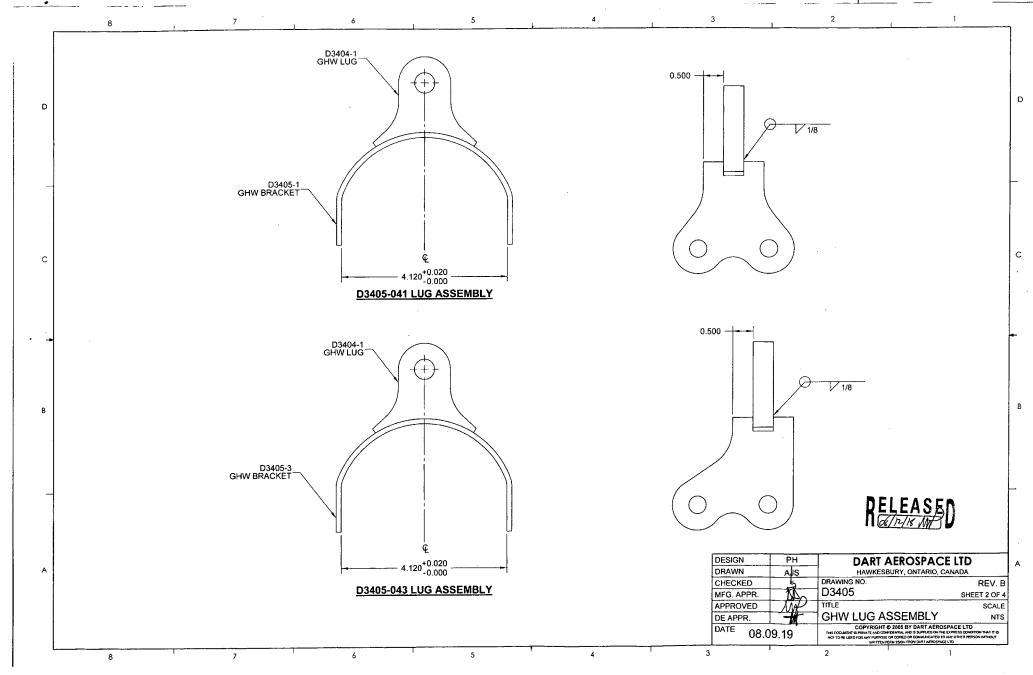
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
1: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -041, 0.85 lbs

-043, 0.87 lbs

C

W/O: DATE STEP Part No:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #-	Fault Category:	N/	P: Vos	No DO	۸.	Data			
	Resolution:		Disposition:	Q	A: N/C (closed:		Date: _			
NCR:			WORK ORDER NON-CON	FORMANC	E (NC	R)	<u> </u>				
			Corrective Action	Section B			т Т				

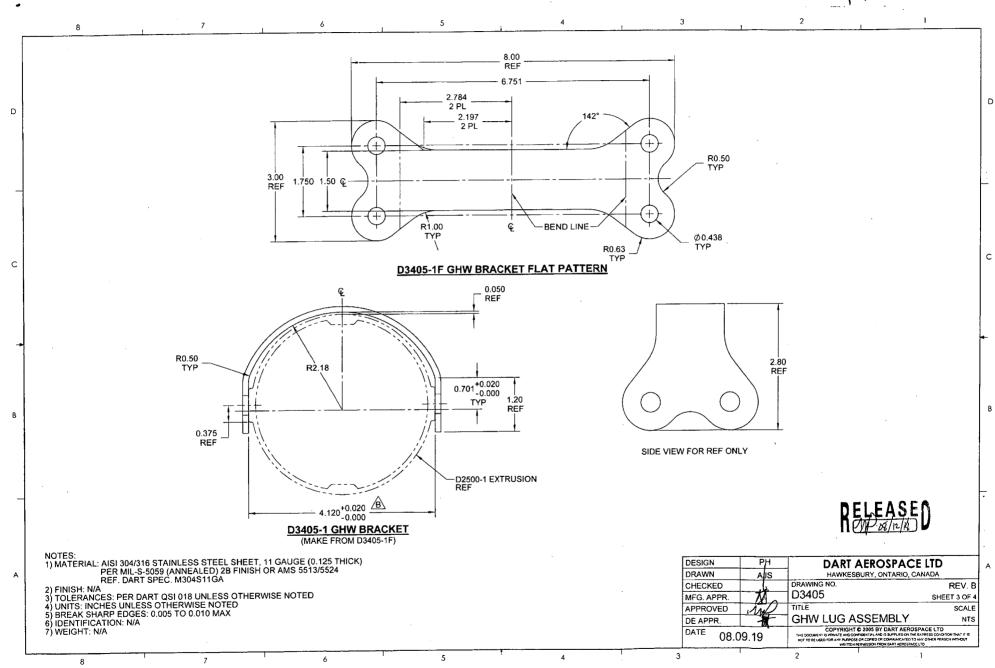
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Dort No.		DAD #	NOD: Yes	N- 50			Bata				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
R	esolution:	Disposition:	QA: N/C Closed:	Date:

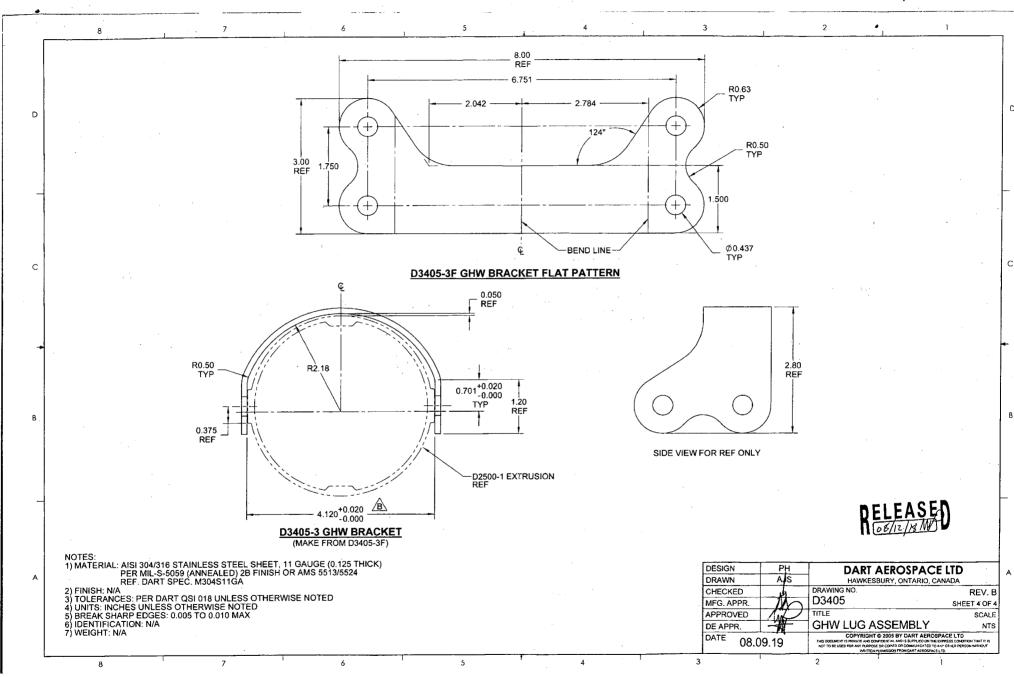
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
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	WORK ORDER CHANGES									
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto				
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	STEP					STEP PROCEDURE CHANGE By Date Qty Chief Eng /				

Part No:PA	AR #: Fault Catego	ory: NCR: Yes No	DQA: Date:
Resolution:	Disposition:	QA: N/C Close	d: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	0750	Description of NC		Corrective Action Section B			Approval	Anneoval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector			
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W/O: WORK ORDER CHANGES				æ '			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		_ PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date: _	
	Resolution:		Disposition:	QA: N/C C	losed	:	Date: _	

	Resolution:		Disposition: QA: N/C Closed: Date: _					
NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)		-	***************************************
	T _	Description of NC		Corrective Action Section 1	3 .	Verification	Approval	Approval QC inspector
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	
:				VALUE				
	;							
			,					
NOTE D								